

Date: Monday, 18/08/2008 10:26:57 AM  
 User: Julie Lecocq

## Process Sheet

SPLIT - \$ 3

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM  
 Job Number : 41288  
 Estimate Number : 12884  
 P.O. Number :  
 This Issue : 18/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : MACHINED PARTS  
 Previous Run : 36421  
 Part Number : D3560044  
 Drawing Number : D3560 REV D  
 Project Number : N/A  
 Drawing Revision : D  
 Material :  
 Due Date : 10/09/2008 Qty: 50 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08.8.18  
 Comment : Est Rev:A New Issue 07.05.24 EC \\  
 Est Rev B ECN 987 07.10.09 EC verified by DD  
 Est Rev:C ECN1048 07-12-18 DD verified by: EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .500 x 5.00



Comment: Qty.: 1.3598 f(s)/Unit Total: 13.5975 f(s)  
 6061-T6 Bar 0.50" x 5.00" M108854X4  
 Batch: M109025X6

JL 08/08/25

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blanks 15.500" long

DIP 08/10/07

(5)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: AA & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

DIP 08/08/27

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLD 08-08-27

(10)





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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41288

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/09/02

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

PLATE

B 42279

SP

08.10.01 (5x)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

### STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch ( 65 deg C ) SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP

SP 08.10.01 (5x)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.10.01 (5)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-10-01 (5)





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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41288

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL

08-10-02

(X5)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ

08/10/02

(5)

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

batch:

B37113

08/10/02

(5)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

08/10/02

(5)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/02

(+5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

152

11/10/02

(5x)

50

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/03

1/1

Job Completion

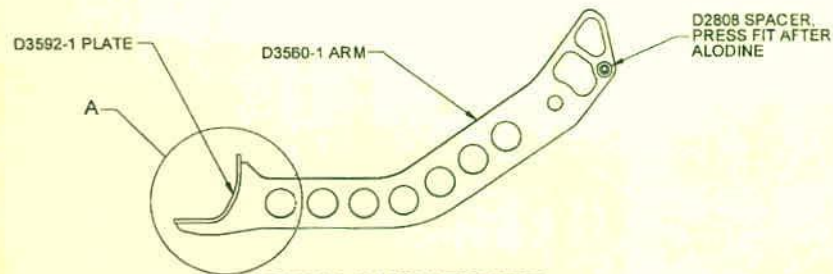


u 08/10/03

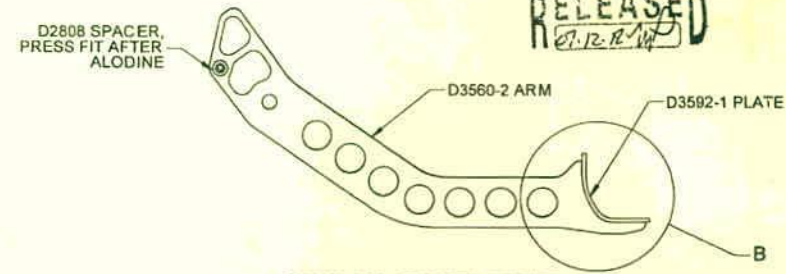




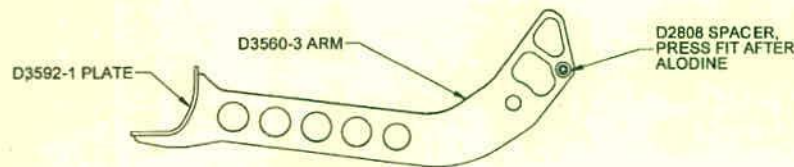
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07.12.16



**D3560-041 ARM WELDMENT**



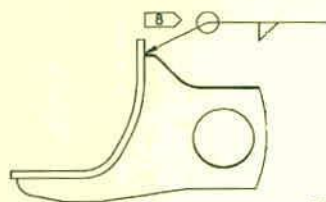
**D3560-042 ARM WELDMENT**



**D3560-043 ARM WELDMENT**



**D3560-044 ARM WELDMENT**



**DETAIL A  
SCALE 1:2**

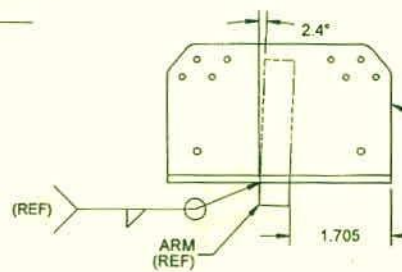
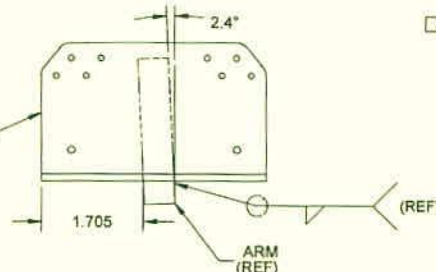
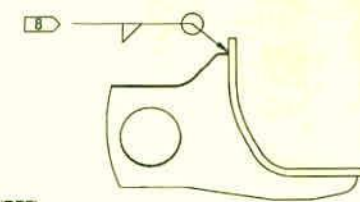


PLATE  
(REF)



ARM  
(REF)



**DETAIL B  
SCALE 1:2**

**PARTS LIST**

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3560** REV. D  
TITLE **ARM WELDMENT** SCALE 1:4  
SHEET 1 OF 5

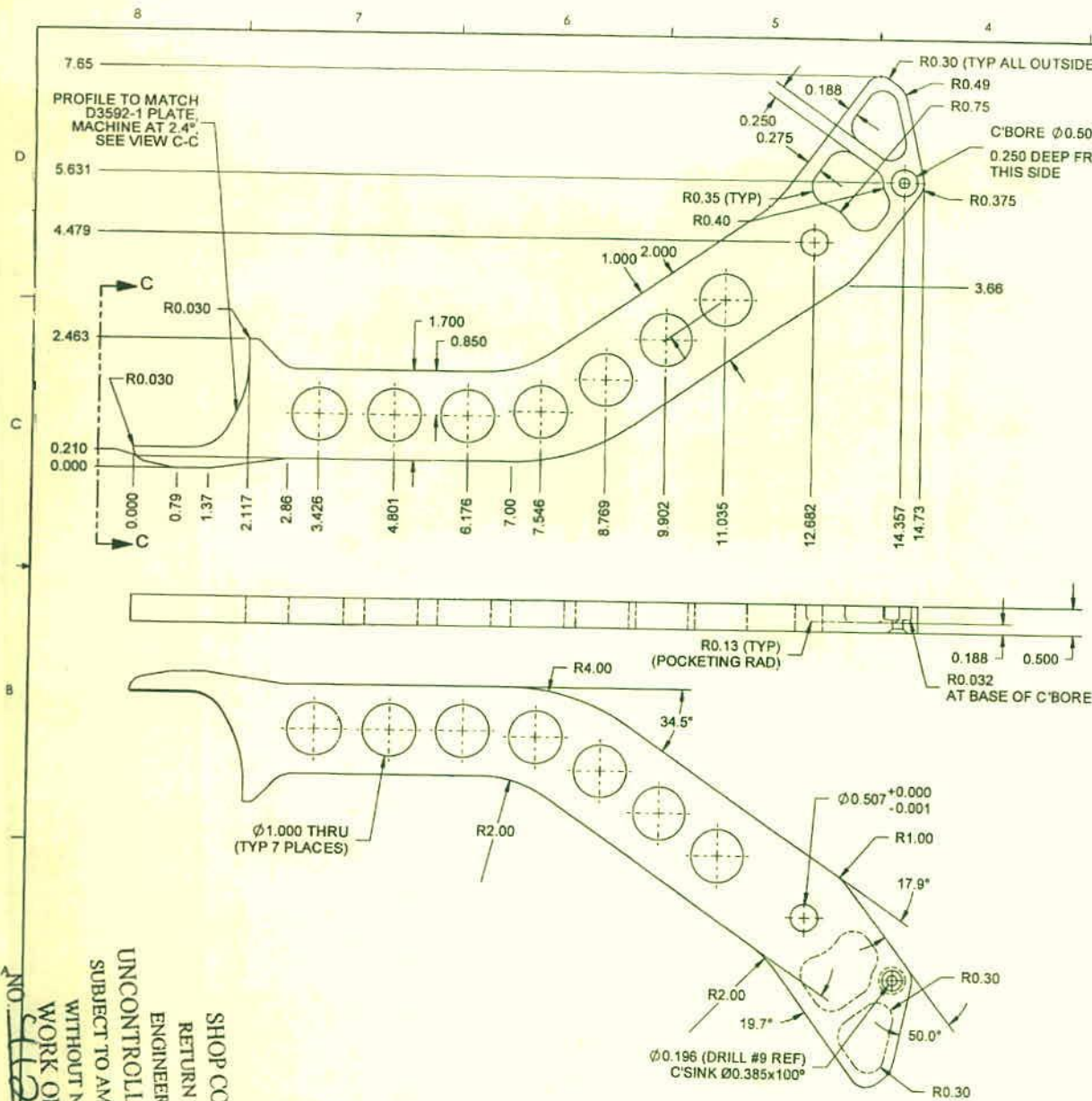
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**NOTES:**  
1. MATERIAL: N/A  
2. FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3. TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4. UNITS: INCHES UNLESS OTHERWISE NOTED  
5. BREAK SHARP EDGES: 0.005 TO 0.015 MAX  
6. IDENTIFICATION: N/A  
7. WEIGHT: 1.2 lbs (TYP)  
8. WEIGHING PER DART QSI 004

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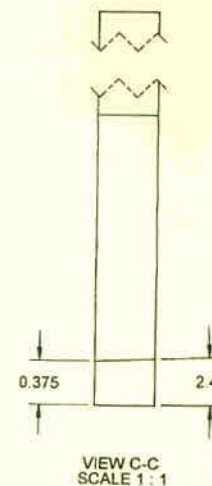




### D3560-1 ARM WELDMENT

#### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



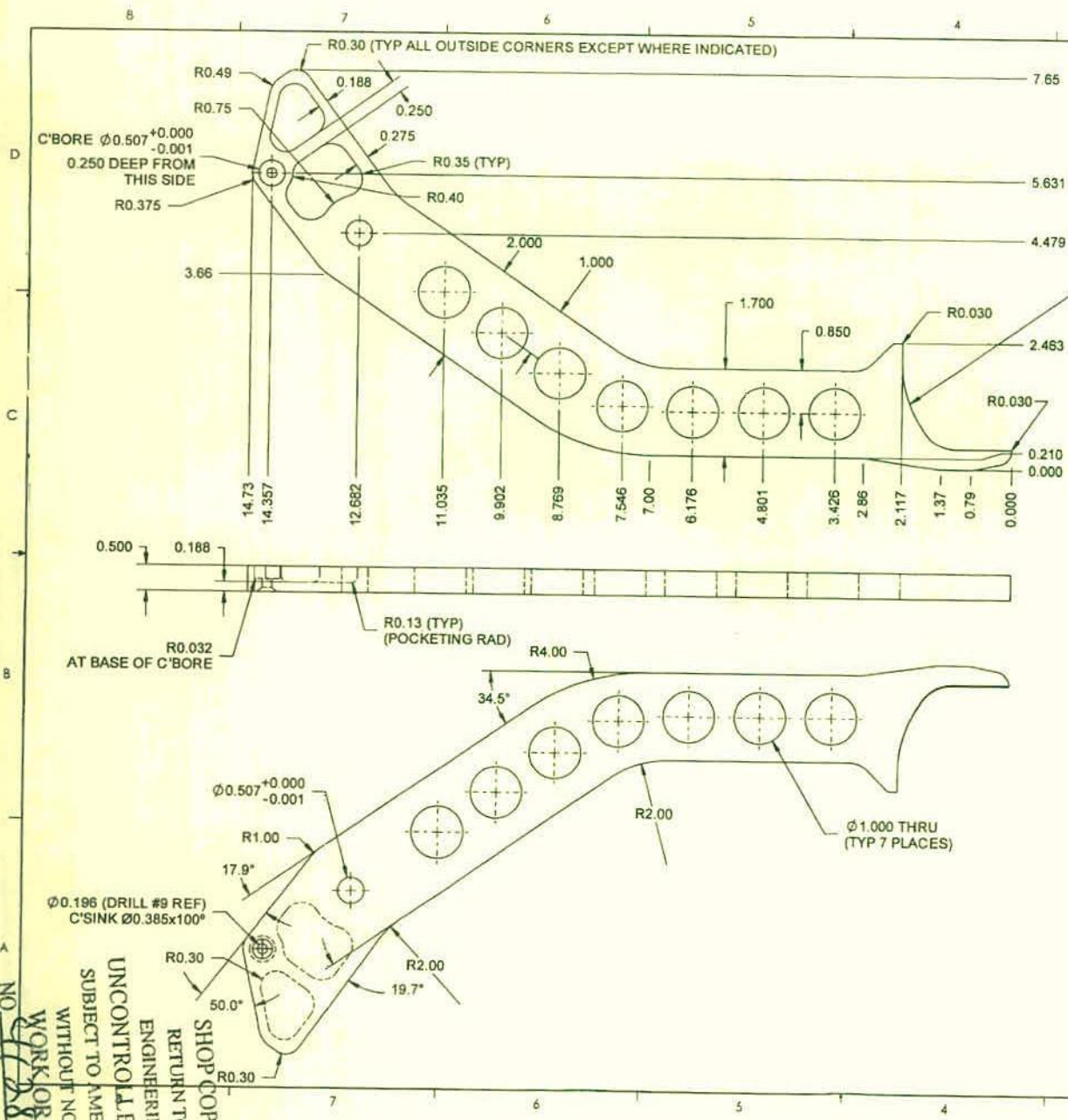
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DRAWN	<i>gc</i>		
CHECKED	<i>g</i>	DRAWING NO	REV. D
MFG. APPR.	<i>g</i>	D3560	SHEET 2 OF 5
APPROVED	<i>My D</i>	TITLE	SCALE
DE APPR.	<i>g</i>	ARM WELDMENT	1/2
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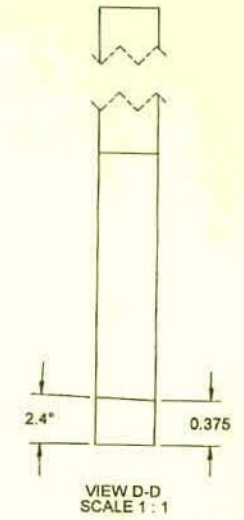




PROFILE TO MATCH  
D3592-1 PLATE,  
MACHINE AT 2.4",  
SEE VIEW D-D

**D3560-2 ARM**

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs



DESIGN	gp	<b>DART AEROSPACE LTD</b>	
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MFG. APPR.	gc	SHEET 3 OF 5	
APPROVED	gc	TITLE <b>ARM WELDMENT</b>	SCALE 1:2
DE APPR.	gc	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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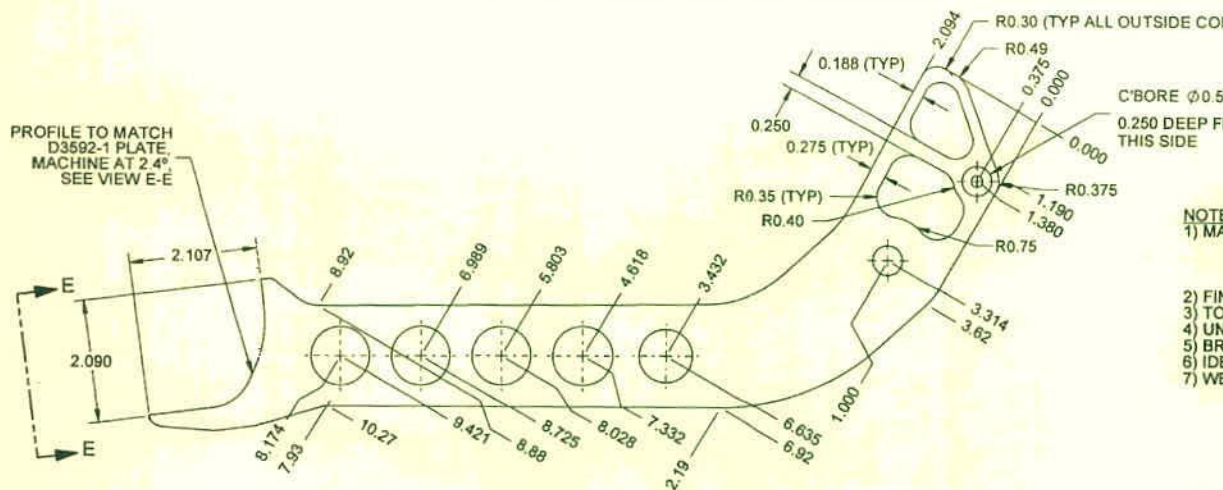
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PROFILE TO MATCH  
D3592-1 PLATE  
MACHINE AT 2.4°  
SEE VIEW E-E



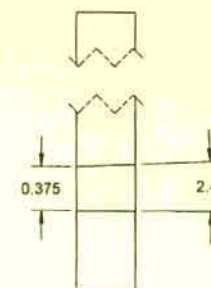
### D3560-3 ARM

#### NOTES:

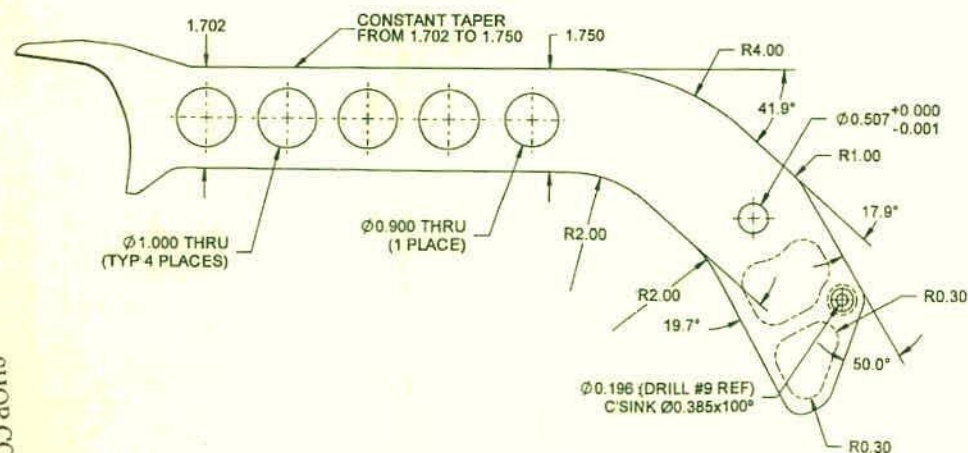
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

R0.13 (TYP)  
(POCKETING RAD)

R0.032  
AT BASE OF C'BORE



VIEW E-E  
SCALE 1:1



DESIGN		DART AEROSPACE LTD	
DRAWN	AC	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		SHEET 4 OF 5	
APPROVED	WMP	TITLE	SCALE
DE APPR.	*	ARM WELDMENT	1:2
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Arm		<b>Part Number:</b>	D3560-4
<b>Inspection Dwg:</b> D3560	<b>Rev:</b> B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	0.506	✓			
Ø0.196	+0.005/-0.001	0.198	✓			
Ø1.000	+0.010/-0.001	1.008	✓			
Ø0.900	+0.010/-0.001	0.902	✓			
0.500	+/-0.010	0.490	✓			
0.250	+/-0.010	0.248	✓			
0.275	+/-0.010	0.272	✓			
0.188	+/-0.010	0.190				
2.000	+/-0.010	2.010				
1.750	+/-0.010	1.754	✓			
1.702	+/-0.010	1.704	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	380 x 108	✓			
0.250 Deep	+/-0.010	0.240	✓			

<b>Measured by:</b>	DJP
<b>Date:</b>	08/08/22

<b>Audited by:</b>	[Signature]
<b>Date:</b>	06/10/02

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	[Signature]

